

Work Order ID 125456

Wednesday, October 08, 2014 7:43:47 AM

125456

Page 1

Item ID: D3891-4

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 10/8/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/8/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-10-08 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3891	A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3891

Dwg Rev: AProg Rev: A

2-Deburr if necessary

50DAS
23
9-8914-10-8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

50DAS
23
9-8914-10-8

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Page 2

Item ID: D3891-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 10/8/2014 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 10/8/2014 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						(5)			DAS
QC	Memo	0.00							38 14-10-9
Quality Control									9-89
130	Identify as per dwg & Stock Location: <u>S7S16</u>	0.00							
130									DAS
Packaging	Memo	0.00				5			06
Packaging									9-89
									OCT 10 2014
140	QC21- Final Inspection - Work Order Release	0.00							
140									14/10/14
QC	Memo	0.00							
Quality Control									

14-10-10

Picklist Print

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Page 1

Work Order ID: 125456

125456

Parent Item: D3891-4

D3891-4

Parent Item Name: Gasket

Start Date: 10/8/2014

Required Date: 10/8/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	359.7200	2.963	16		DAS 23 9-89	14-10-8
M4111NS 125										**			
4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"													

Location

MAT052

m127905

m130068

Loc Qty

359.72

134.72

225

Loc Code

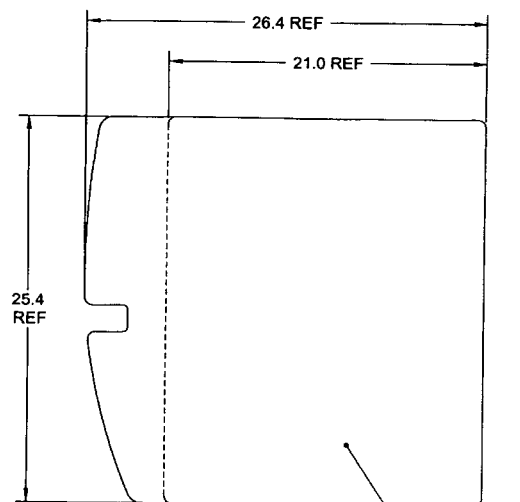
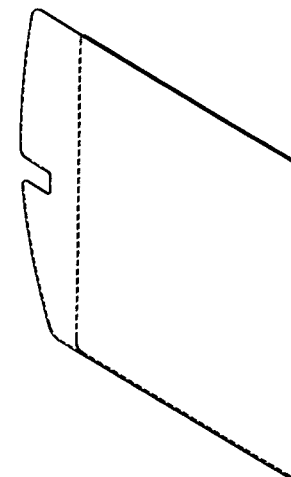
130068

PARTS LIST

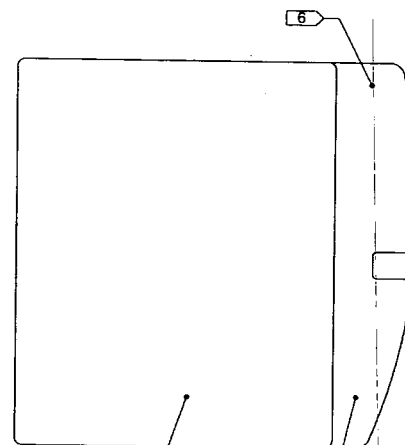
ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 125456 MLJ

14-10-08



TEXTURED
SIDE
D3891-1
PANEL



D3891-3
GASKET

UNTEXTURED
SIDE

D3891-041 PANEL, FWD LH

NOTES:

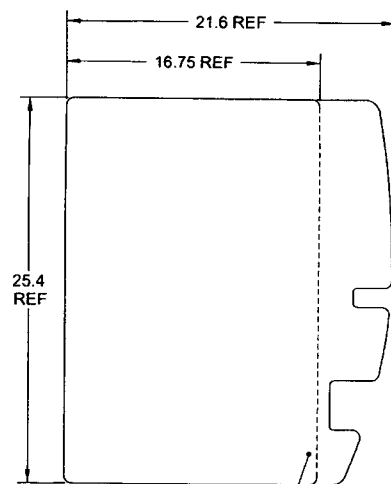
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED
C9/26/16 W

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	90	D3891	SHEET 1 OF 6
APPROVED	90	TITLE	SCALE
DE APPR.	90	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

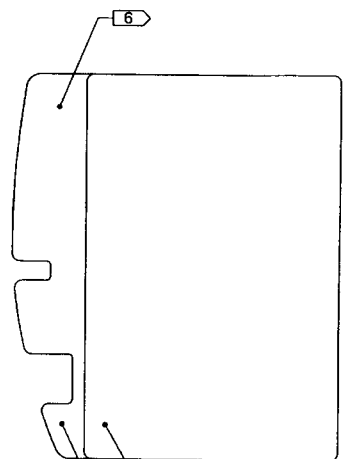
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE



D3891-2 PANEL

TEXTURED SIDE



D3891-4 GASKET 6

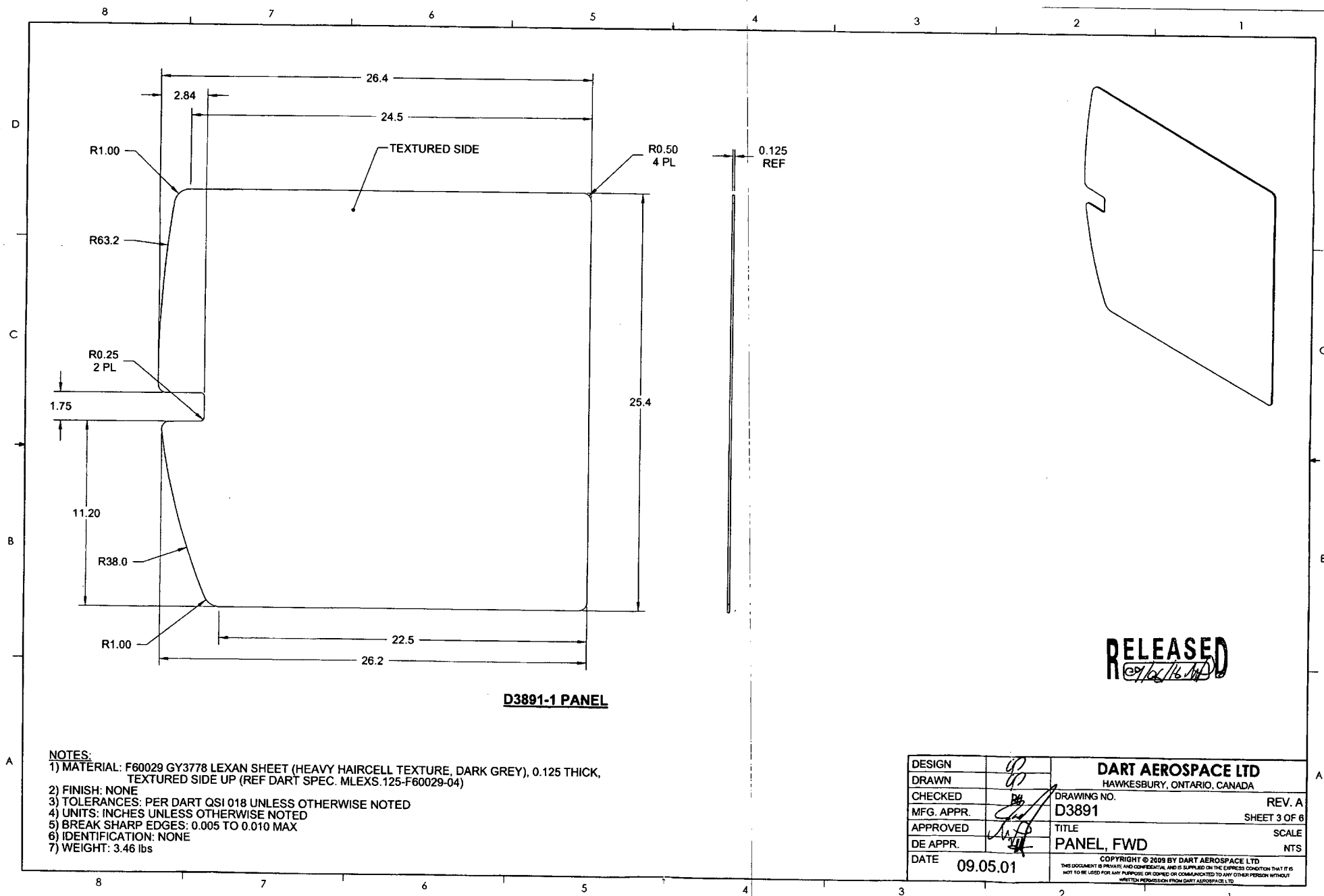
UNTEXTURED
SIDE**D3891-042 PANEL, FWD RH**

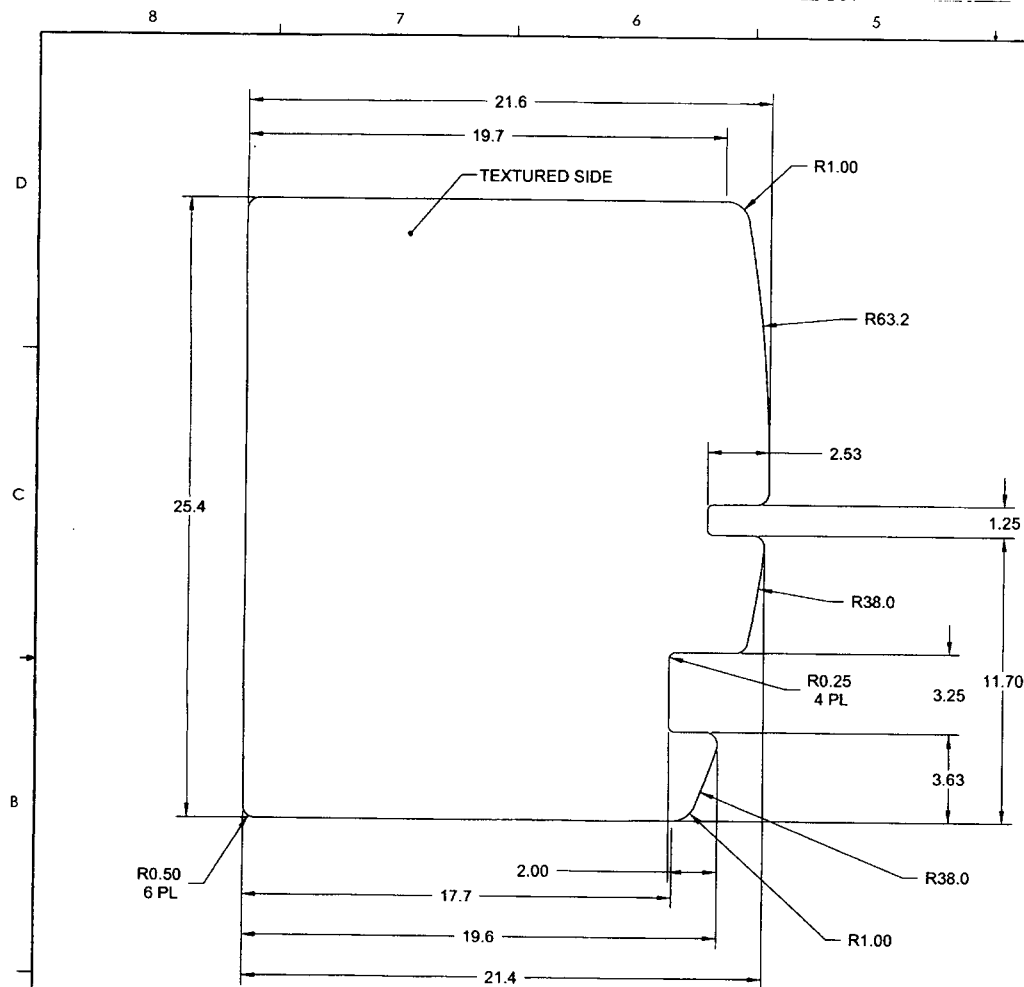
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

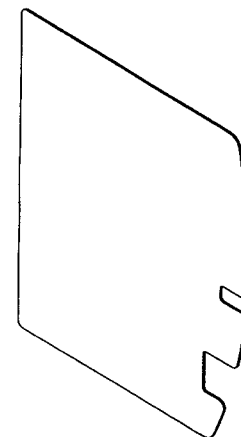
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09/05/01

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DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	92	D3891	SHEET 2 OF 6
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0.125
REF



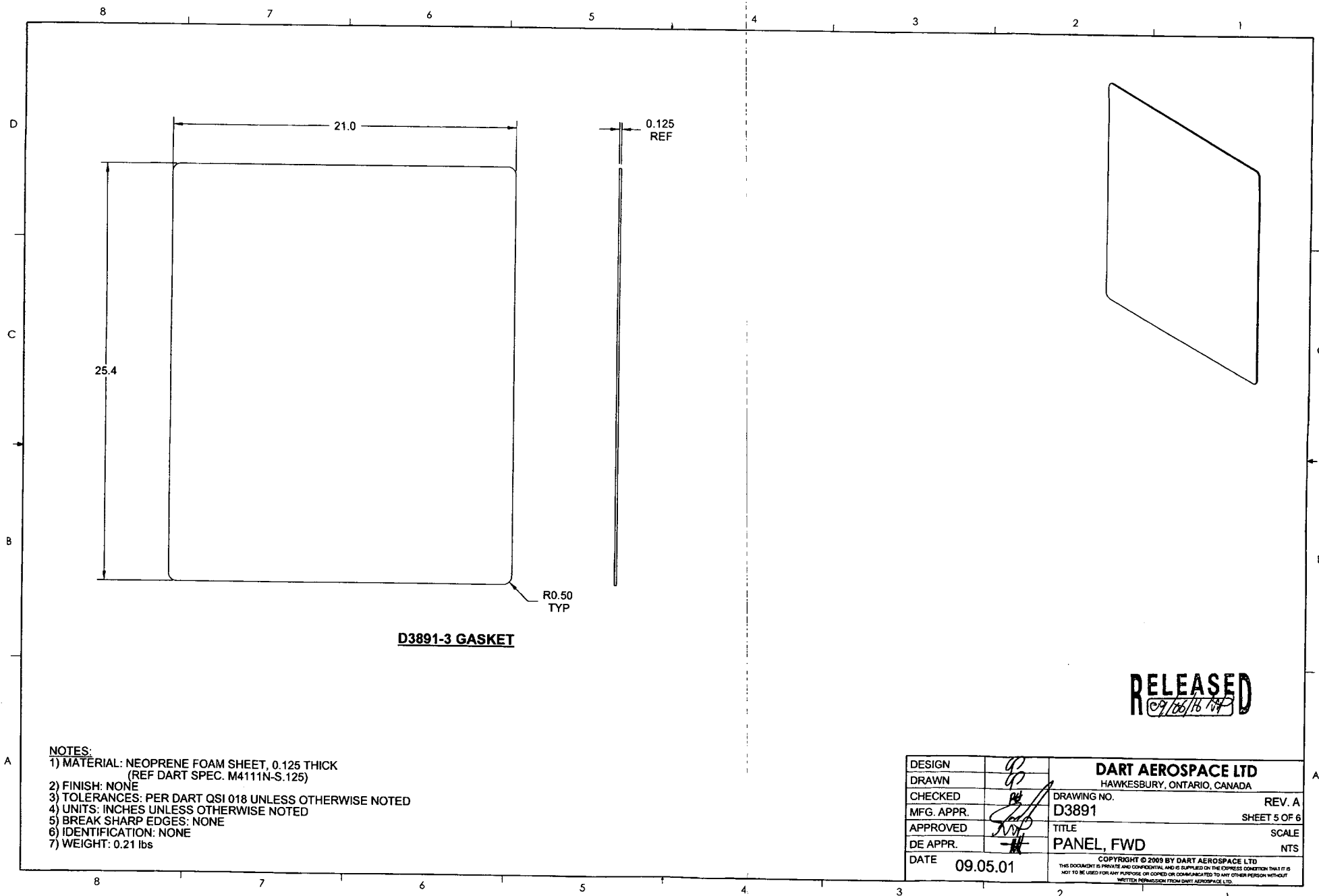
D3891-2 PANEL

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

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09/05/01

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MFG. APPR.	97	D3891	SHEET 4 OF 6
APPROVED	97	TITLE	SCALE
DE APPR.	97	PANEL, FWD	NTS
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D3891-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

RELEASED
09/06/16

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CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 5 OF 6
APPROVED	92	TITLE	SCALE
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